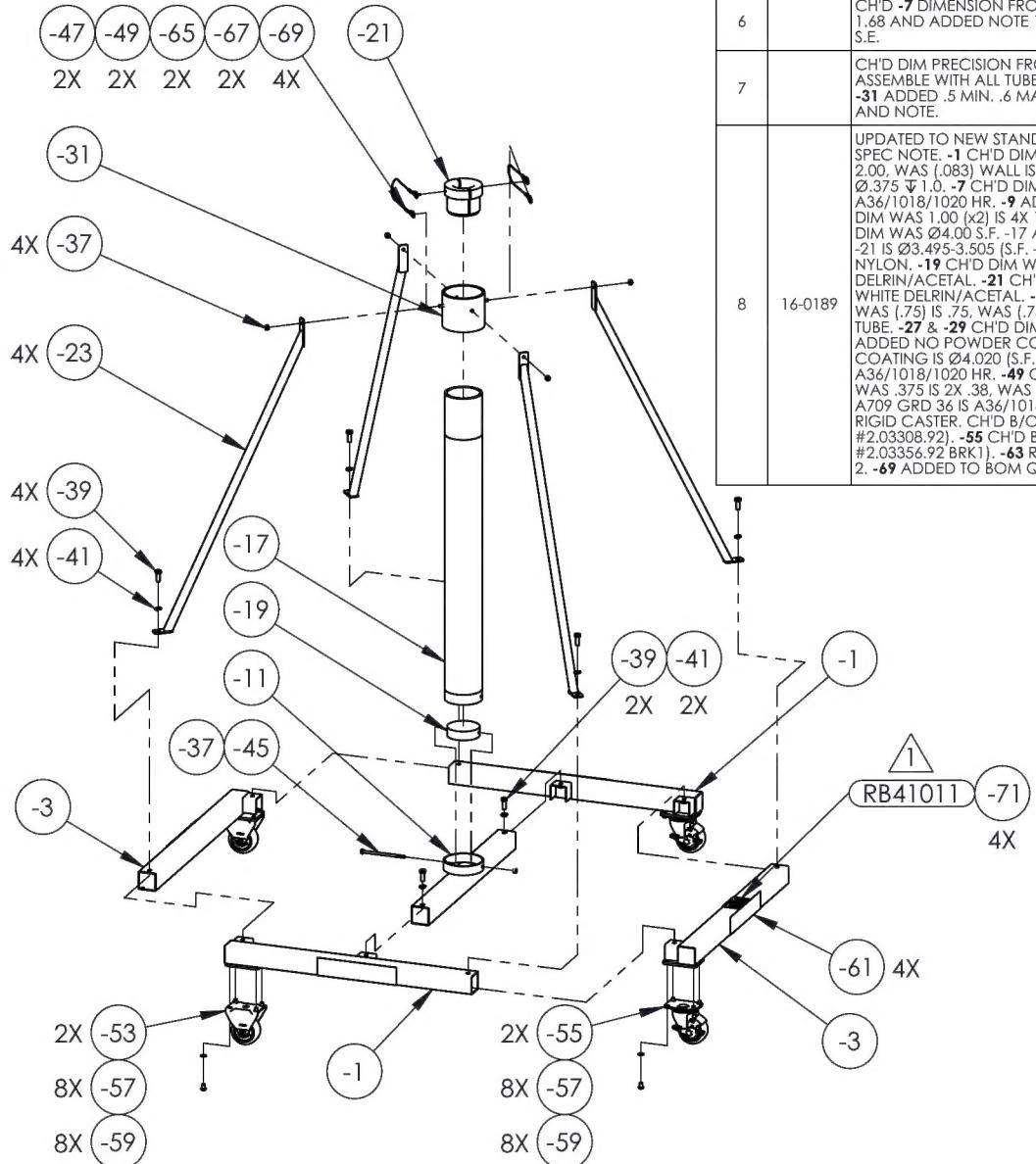


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADJUSTED -17 TO ALLOW FOR OVERSIZE PLASTIC TUBE CONDITIONS.	11/24/2008	WP	RW
2		ADDED WHEEL PADS, CASTERS & HARDWARE & CLEARANCE HOLES PER CUSTOMER REQUEST, SEPARATED -5 INTO -5a & -5b BECAUSE OF CLEARANCE HOLES. ALSO CHANGED TUBE END CAPS FROM PLASTIC OUTWATER #164-U-2-BLK TO WELDED METAL.	3/2/2009	WP	RW
3		CH'D P/N -7 OVERALL LENGTH FROM 4.872 & DIM. TO FIRST FOLD LINE FROM 1.606 PER W.P.	10/27/2009	WP	
4		CH'D LENGTH -33 FROM 4.250 TO 3.750 PER D.W.	1/15/2010	RJC	RW
5		CH'D Ø.405 HOLE TO A SLOT ON BOTH ENDS -13 PER G.E. MOVED ALL PARTS TO SEPARATE PAGES.	3/3/2011	RJC	GE
5A		ADDED NOTES 1 & 2, CH'D ALL HARDWARE TO S.S. & ADDED P/N'S PER R.W.	9/6/2011	RJC	RW
6		CH'D -7 DIMENSION FROM 1.825 +.000-.020 TO 1.825 +.000-.025, CH'D 1.500 TO 1.50, CH'D 1.680 TO 1.68 AND ADDED NOTE 1 PER S.E. CH'D TOLERANCE ON ALL SHEETS FROM .XXX ± .005 & .XX ± .01 PER S.E.	6/4/2012	RJC	SE
7		CH'D DIM PRECISION FROM .XXX TO .XX ON NON-CRITICAL PARTS. -1, -3, & -23 DELETED NOTE 1 WAS ASSEMBLE WITH ALL TUBE SEAMS ON THE BOTTOM. -5a & -5b DELETED NOTE WAS SEAM ON BOTTOM. -31 ADDED .5 MIN. & .6 MAX. DIM. -35 CH'D FROM STEEL TO STAINLESS & ADDED DWG TO MODIFY AND NOTE.	8/12/2013	RJC	DW
8	16-0189	UPDATED TO NEW STANDARDS. ADDED ENGRAVE NOTE FOR PLACARD. REMOVED GENERIC PLATE SPEC NOTE. -1 CH'D DIM WAS 14.00 IS (14.00). -5a & -5b CH'D DIMS WAS (2.00) IS 2.00, WAS (2.00) IS 2.00, WAS (.083) WALL IS .08, WAS Ø.405 ONE WALL IS Ø.405 ↓ 1.0, WAS Ø.375 (x3) ONE WALL IS 3X Ø.375 ↓ 1.0. -7 CH'D DIMS WAS 1.68 IS 2X 1.68, WAS .075 IS .08. CH'D MAT'L WAS A709 GRADE 36 IS A36/1018/1020 HR. -9 ADDED B/O REF #93560A160. -11 CH'D DIM WAS 24.50 IS (24.50). -13 CH'D DIM WAS 1.00 (x2) IS 4X 1.00, WAS (2.00) IS 2.00, WAS (.083) WALL IS .08. -15 CH'D DIM WAS Ø4.00 S.F. -17 AFTER POWDER COATING IS Ø4.020 (S.F. -17). -21 CH'D DIM WAS Ø3.500 S.F. -17 IS Ø3.470 (S.F. -17). CH'D MAT'L WAS DELRIN IS WHITE DELRIN/ACETAL. -21 CH'D DIM WAS Ø3.490 IS Ø3.480-3.490 (S.F. -17). CH'D MAT'L WAS DELRIN IS WHITE DELRIN/ACETAL. -23 CH'D DIM WAS (37.34) IS (37.37). ADDED WELD SYMBOLS. -25 CH'D DIMS WAS (.75) IS .75, WAS (.75) IS .75, WAS (.083) WALL IS .08. CH'D MAT'L WAS 1018 SQ. TUBE IS STEEL TUBE. -27 & -29 CH'D DIM WAS (.125) IS .13. CH'D MAT'L WAS A709 GRD 36 IS A36/1018/1020 HR. -31 ADDED NO POWDER COAT ON THREADS NOTE. -33 CH'D DIM WAS Ø4.000 S.F. -17 AFTER POWDER COATING IS Ø4.020 (S.F. -17). -43 CH'D DIM WAS 16ga. (.060) IS .06. CH'D MAT'L WAS A709 GRD 36 IS A36/1018/1020 HR. -49 CH'D B/O REF WAS #30345T11 IS #CL-2-C. -51 CH'D DIMS WAS (.25) IS .25, WAS .375 IS 2X .38, WAS 3.000 IS 2X 3.000, WAS .50 IS 2X .50, WAS 1.750 IS 2X 1.750. CH'D MAT'L WAS A709 GRD 36 IS A36/1018/1020 HR. -53 CH'D DESCRIPTION WAS 3 in. RIGID CASTER W/ BRAKE IS 3 in. RIGID CASTER. CH'D B/O REF WAS APPLIED INDUSTRIAL #1F9303B25002100 IS (GALIFCO, COLSON #2.03308.92). -55 CH'D B/O REF WAS APPLIED INDUSTRIAL #2F9803B25002100 IS (GALIFCO, COLSON #2.03356.92 BRK1). -63 REPLACED W/ RB41011. -65 ADDED TO BOM QTY 2. -67 ADDED TO BOM QTY 2. -69 ADDED TO BOM QTY 4. -71 ADDED TO BOM QTY 4.	10/25/2016	DPD	JAG

NOTE:

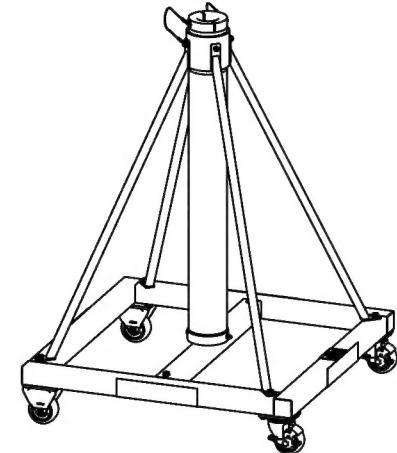
1 ENGRAVE T/N, S/N, "MADE IN USA", SWL 250 LBS.

DART AEROSPACE	
TITLE: FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657	
REV 8	
MAT'L UNLESS OTHERWISE SPECIFIED HEAT DIMENSIONS ARE IN INCHES TREAT FRACTIONS ± 1/8 FINISH .XXX ± .010 ANGLES ± 1° SPEC .XX ± .03 SURFACES = 125 DRAWN BY: PERRITT CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM & TOL PER ASME Y14.5M-2009	
SCALE	1:20
DATE	10/3/2008
SHEET 1 OF 23	

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REVISIONS									
REV	ECR	DESCRIPTION					DATE	INITIAL	APPROVED
8	16-0189	REMOVED GENERIC PLATE SPEC NOTE. -9 ADDED B/O REF #93560A160. -49 CH'D B/O REF WAS #30345T11 IS #CL-2-C. -53 CH'D DESCRIPTION WAS 3 in. RIGID CASTER W/ BRAKE IS 3 in. RIGID CASTER. CH'D B/O REF WAS APPLIED INDUSTRIAL #1F9303B25002100 IS (GALIFCO, COLSON #2.03308.92). -55 CH'D B/O REF WAS APPLIED INDUSTRIAL #2F9803B25002100 IS (GALIFCO, COLSON #2.03356.92 BRK1). -63 REPLACED W/ RB41011 . -65 ADDED TO BOM QTY 2. -67 ADDED TO BOM QTY 2. -69 ADDED TO BOM QTY 4. -71 ADDED TO BOM QTY 4.					10/25/2016	DPD	JAG

ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.				
			X		-1	2		BASE SIDE WELDMENT			3
			X		-3	2		BASE END WELDMENT			4
				1	-5a	1		BASE SIDE TUBE	STEEL TUBE 		5
				1	-5b	1		BASE TUBE	STEEL TUBE 		6
				1	2	-7		CLIP	A36/1018/1020 HR		7
				1	2	B/O	-9	WELD NUTS	STEEL	3/8-16 (MCMASTER-CARR #93560A160)	3 & 4
			X		-11	1		BASE CENTER TUBE WELDMENT			8
				1	-13	1		BASE CENTER TUBE	STEEL TUBE 		9
				1	-15	1		BASE CENTER TUBE RING	DOM		10
					-17	1		VERTICAL NYLON TUBE	NATURAL, NYLON		11
					-19	1		TUBE BOTTOM PLUG	WHITE DELRIN/ACETAL		12
					-21	1		SUPPORT INSERT	WHITE DELRIN/ACETAL		13
			X		-23	4		BRACE WELDMENT			14
				1	-25	1		BRACE TUBE	STEEL TUBE 		15
				1	-27	1		BOTTOM BRACE TAB	A36/1018/1020 HR		16
				1	-29	1		UPPER BRACE TAB	A36/1018/1020 HR		17
			X		-31	1		TUBE TOP RING WELDMENT			18
				1	-33	1		TUBE TOP RING	DOM		19
				4	-35	1		SOCKET HEAD SET SCREW	S.S.	1/4-20 X 1-1/4 (MCMASTER-CARR #92313A546) MODIFIED	20
					B/O	-37	5	NYLOCK NUT	S.S.	1/4-20 (MCMASTER-CARR #91831A029)	1
					B/O	-39	6	HEX HEAD CAP SCREW	S.S.	3/8-16 X 1 (MCMASTER-CARR #92240A624)	1
					B/O	-41	6	SPLIT RING LOCK WASHER	S.S.	Ø3/8 (MCMASTER-CARR #92146A031)	1
				1	1	-43	1	BASE TUBE END CAP	A36/1018/1020 HR		21
					B/O	-45	1	HEX HEAD CAP SCREW	S.S.	1/4-20 X 4-3/4 (MCMASTER-CARR #91257A105)	1
					B/O	-47	2	BUTTON HEAD CAP SCREW	S.S.	8-32 X 1/2 (MCMASTER-CARR #92949A194)	1
					B/O	-49	2	LANYARD	COATED STEEL	Ø1/16 X 12 (CARR LANE #CL-2-C)	1
				1	1	-51	1	WHEEL PLATE	A36/1018/1020 HR		22
					B/O	-53	2	3 in. RIGID CASTER		(GALIFCO, COLSON #2.03308.92)	1
					B/O	-55	2	3 in. SWIVEL CASTER W/BRAKE		(GALIFCO, COLSON #2.03356.92 BRK1)	1
					B/O	-57	16	BUTTON HEAD CAP SCREW	S.S.	5/16-18 X 1/2 (MCMASTER-CARR #92949A578)	1
					B/O	-59	16	INTERNAL LOCK WASHER	S.S.	Ø5/16 (MCMASTER-CARR #91757A111)	1
					B/O	-61	4	REFLECTIVE TAPE	POLYESTER	2 X 9 (MCMASTER-CARR #599784)	1
					B/O	-65	2	CABLE TAB	ALUMINUM	#10 (CARR-LANE #CL-194-TAB-A)	1
					B/O	-67	2	CABLE TAB	ALUMINUM	Ø1/4 (CARR-LANE #CL-281-TAB-A)	1
					B/O	-69	4	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMASTER-CARR #3896T31)	1
					B/O	-71	4	#2 DRIVE SCREW	STEEL	#2 X 1/4 (MCMASTER-CARR #90081A077)	1
					B/O		1	PLACARD	ALUMINUM	RB41011	1
ASSY -31	ASSY -23	ASSY -11	ASSY -3	ASSY -1							



NOTE:

 MATERIAL MAY VARY DEPENDING ON COMMERCIAL AVAILABILITY.

DART
AEROSPACE

TITLE: FIRE SCOUT ROTOR HEAD STAND

DWG NO.

RBT18657

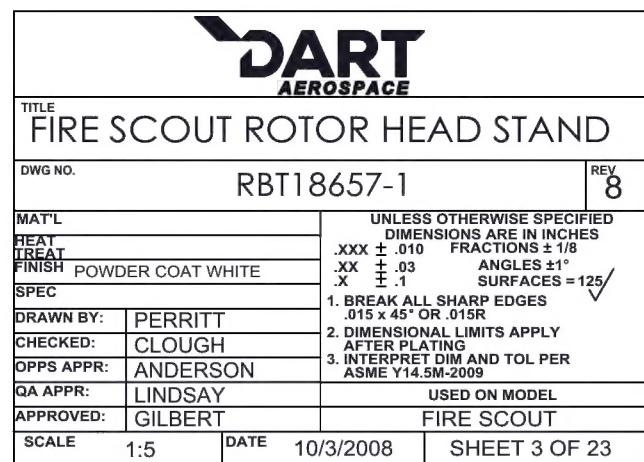
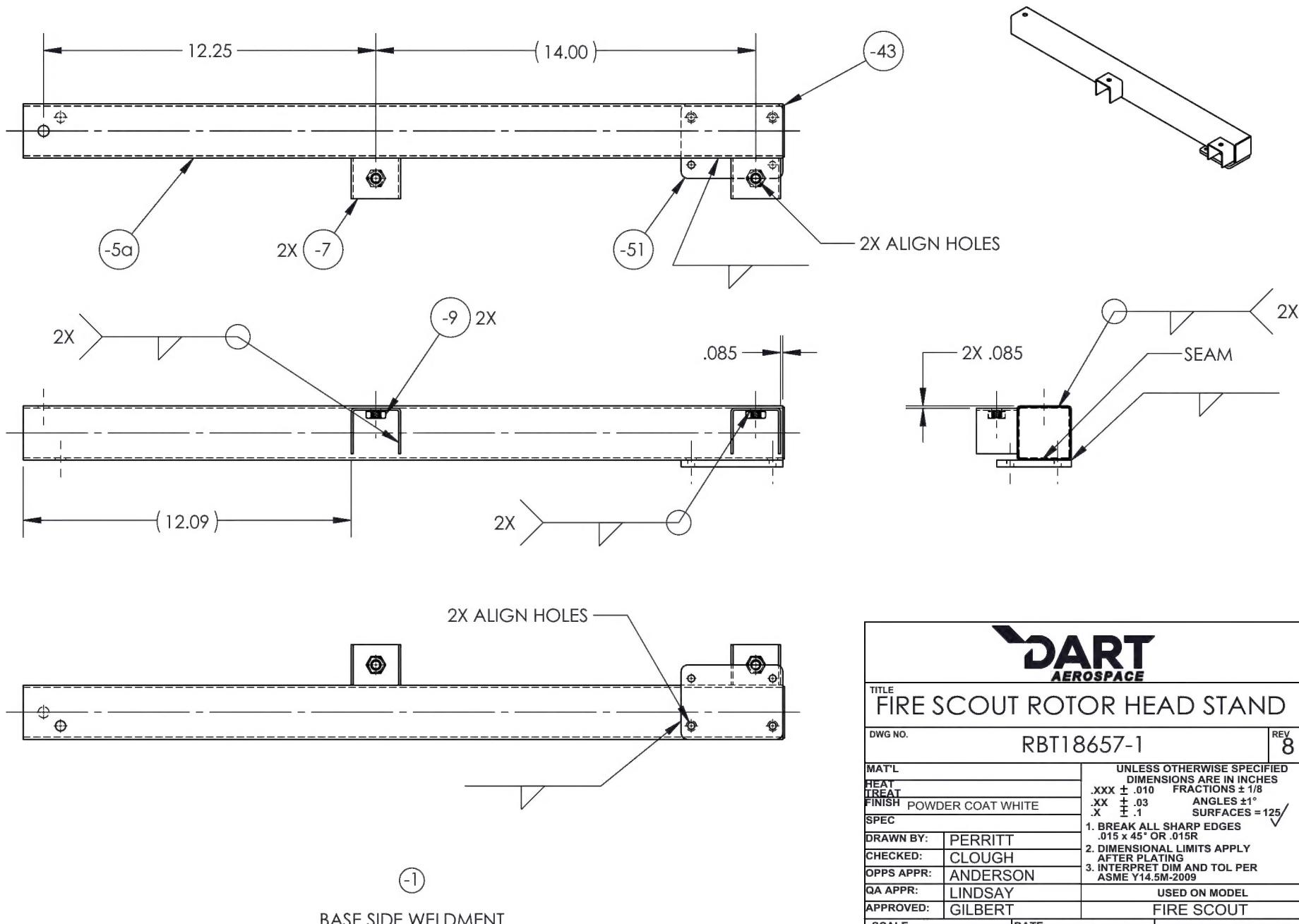
REV 8

MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ± 1°
SPEC	X ± .1 SURFACES = 125 ✓
DRAWN BY:	PERRITT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	1:20
DATE	10/3/2008
USED ON MODEL	
FIRE SCOUT	

1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

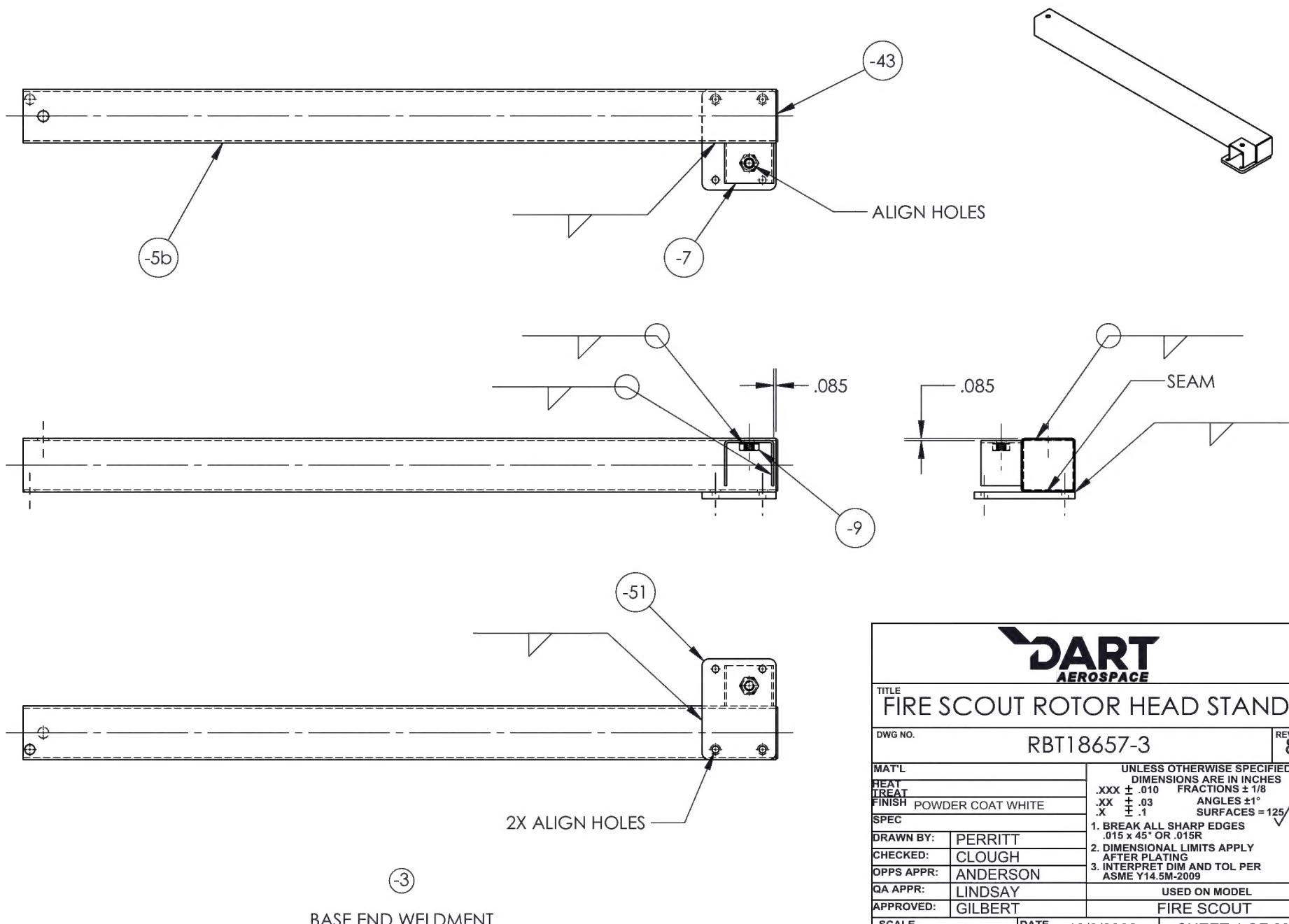
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		-1 DELETED NOTE 1 WAS ASSEMBLE WITH ALL TUBE SEAMS ON THE BOTTOM.	8/12/2013	RJC	DW
8	16-0189	-1 CH'D DIM WAS 14.00 IS (14.00).	10/25/2016	DPD	JAG



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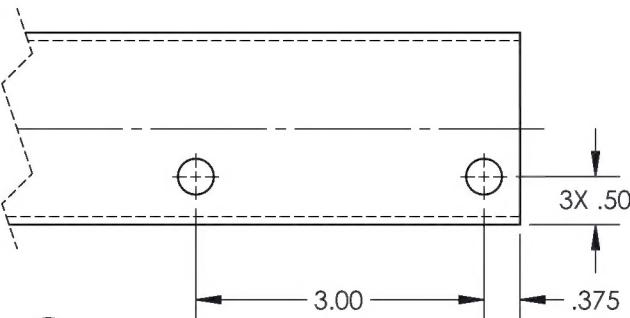
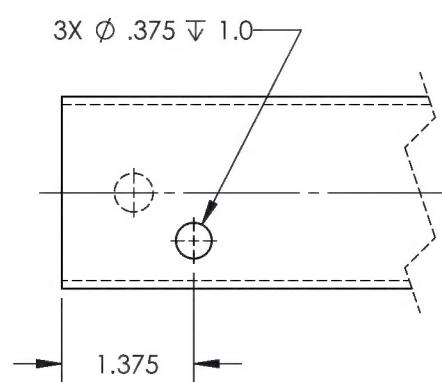
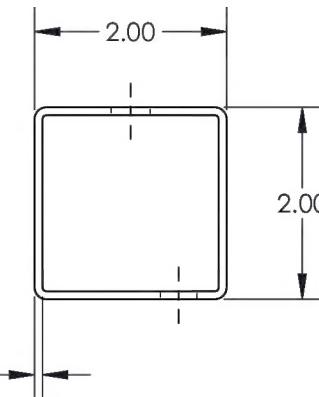
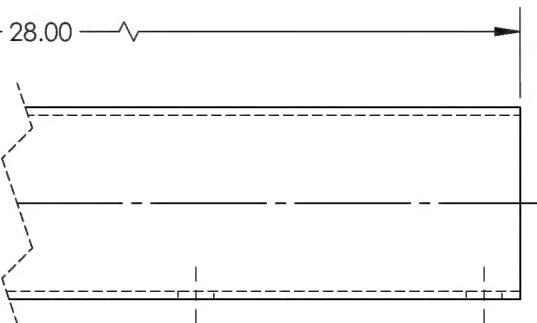
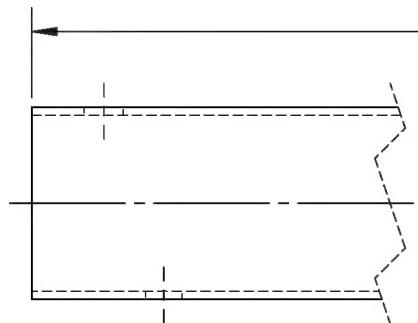
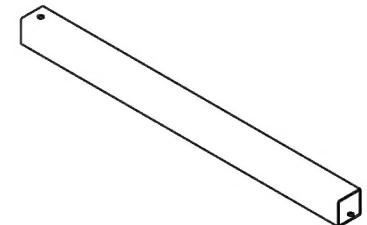
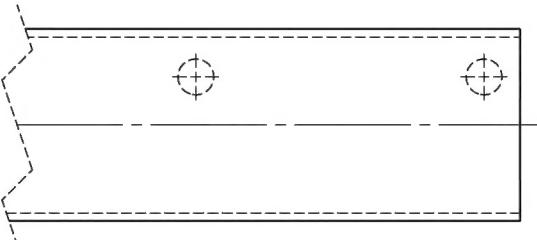
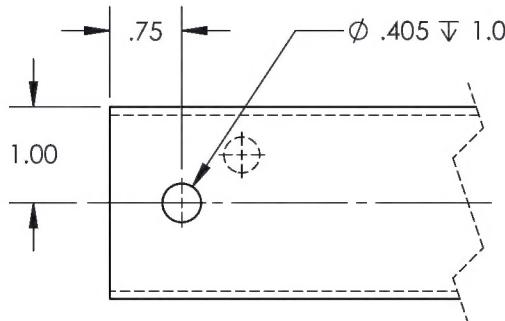
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7			-3 DELETED NOTE 1 WAS ASSEMBLE WITH ALL TUBE SEAMS ON THE BOTTOM.						8/12/2013			RJC			DW		



TITLE		DART	
		AEROSPACE	
DWG NO.		RBT18657-3	
REV		8	
MATERIAL		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT		.XXX ± .010 FRACTIONS ± 1/8	
TREAT		.XX ± .03 ANGLES ± 1°	
FINISH		X ± .1 SURFACES = 125 ✓	
SPEC		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
DRAWN BY:		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
CHECKED:		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
OPPS APPR:		QA APPR: LINDSAY USED ON MODEL	
APPROVED:		GILBERT FIRE SCOUT	
SCALE		1:5	DATE 10/3/2008
		SHEET 4 OF 23	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		SEPARATED -5 INTO -5a & -5b BECAUSE OF CLEARANCE HOLES.	3/2/2009	WP	RW
7		-5a DELETED NOTE WAS SEAM ON BOTTOM.	8/12/2013	RJC	DW
8	16-0189	-5a CH'D DIMS WAS (2.00) IS 2.00, WAS (2.00) IS 2.00, WAS (.083) WALL IS .08, WAS Ø.405 ONE WALL IS Ø.405 ▼ 1.0, WAS Ø.375 (x3) ONE WALL IS 3X Ø.375 ▼ 1.0.	10/25/2016	DPD	JAG



BASE SIDE TUBE

DART
AEROSPACE

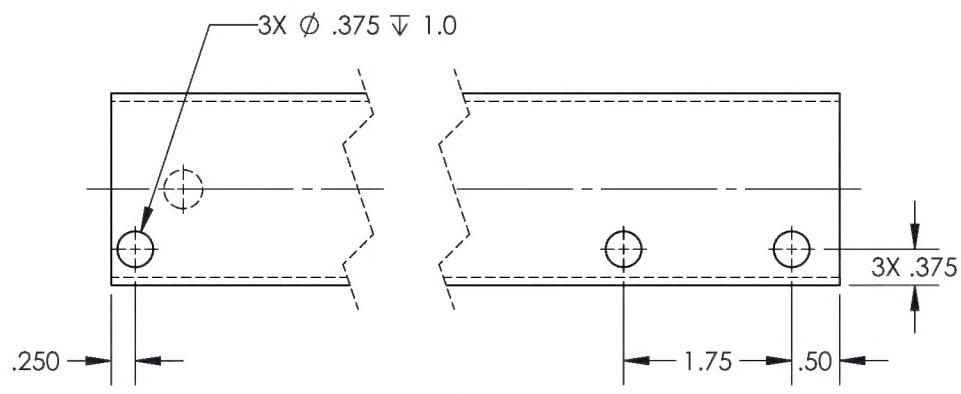
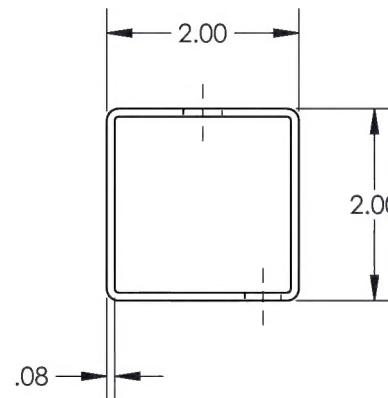
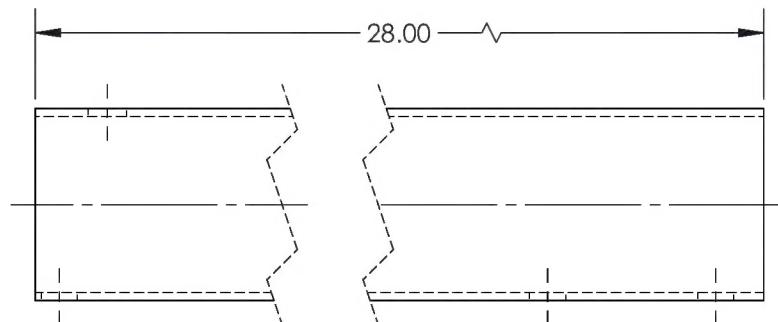
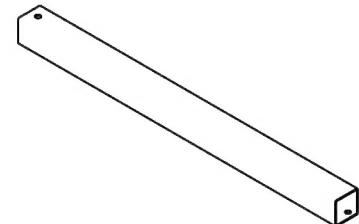
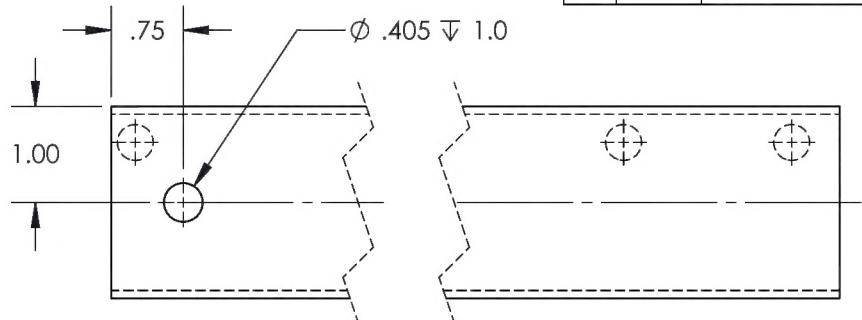
TITLE
FIRE SCOUT ROTOR HEAD STAND

DWG NO. RBT18657-5a **REV** 8

MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH SEE -1	X ± .1 SURFACES = 125
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY:	PERRITT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	FIRE SCOUT
SCALE 1:2	DATE 10/3/2008
SHEET 5 OF 23	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		SEPARATED -5 INTO -5a & -5b BECAUSE OF CLEARANCE HOLES.	3/2/2009	WP	RW
7		-5b DELETED NOTE WAS SEAM ON BOTTOM.	8/12/2013	RJC	DW
8		-5b CH'D DIMS WAS (2.00) IS 2.00, WAS (2.00) IS 2.00, WAS (.083) WALL IS .08, WAS Ø.405 ONE WALL IS Ø.405 ▼ 1.0, WAS Ø.375 (x3) ONE WALL IS 3X Ø.375 ▼ 1.0.	10/25/2016	DPD	JAG



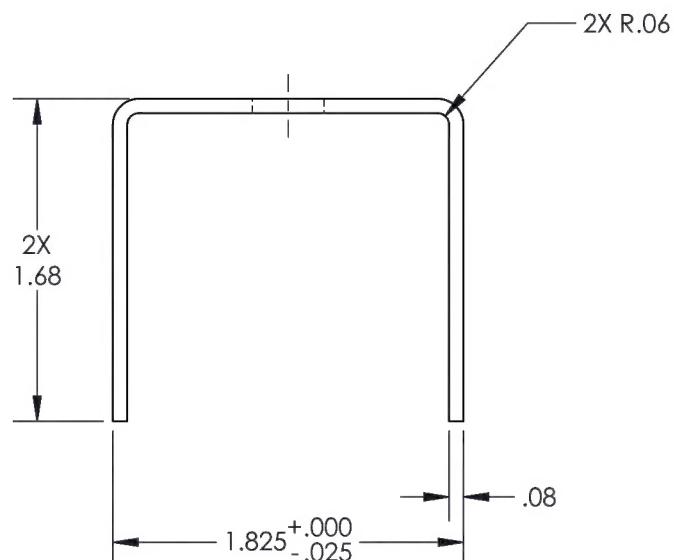
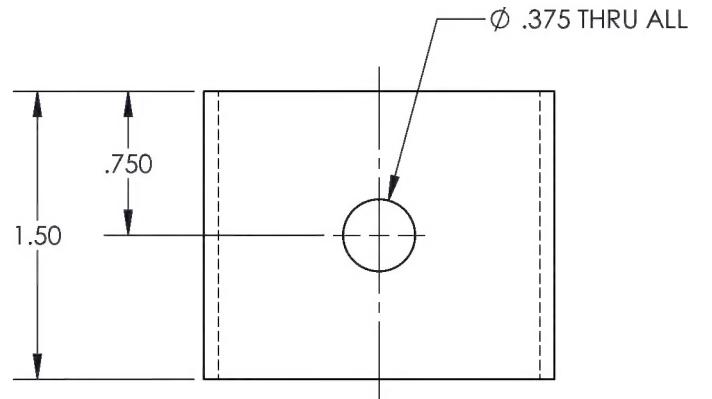
(-5b)

BASE TUBE

DART AEROSPACE	
TITLE	
FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-5b	
REV 8	
MATERIAL STEEL TUBE	
HEAT	
TREAT	
FINISH SEE -3	
SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
X ± .1 SURFACES = 125	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	PERRITT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
FIRE SCOUT	
SCALE	1:2
DATE	10/3/2008
SHEET 6 OF 23	

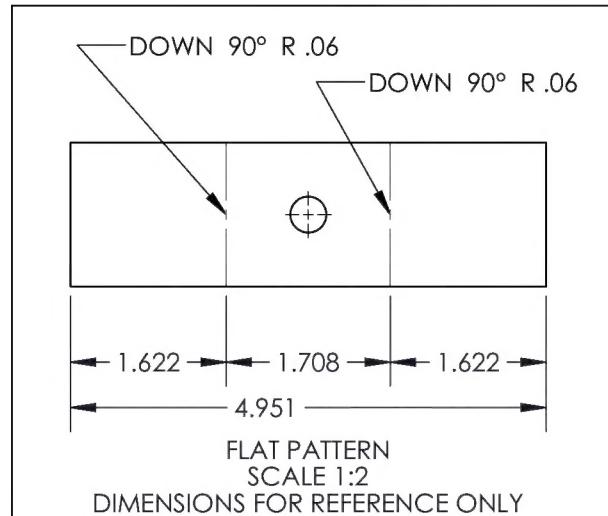
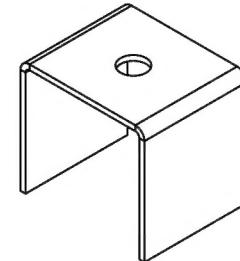
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		CH'D P/N -7 OVERALL LENGTH FROM 4.872 & DIM TO FIRST FOLD LINE TO 1.606 PER W.P.	10/27/2009	WP	RW
6		CH'D -7 DIMENSION FROM 1.825 +.000-.020 TO 1.825 +.000-.025, CH'D 1.500 TO 1.50, CH'D 1.680 TO 1.68 AND ADDED NOTE 1 PER S.E.	6/4/2012	RJC	SE
8	16-0189	-7 CH'D DIMS WAS 1.68 IS 2X 1.68, WAS .075 IS .08. CH'D MAT'L WAS A709 GRADE 36 IS A36/1018/1020 HR.	10/25/2016	DPD	JAG



(7)

CLIP



DART
AEROSPACE

TITLE
FIRE SCOUT ROTOR HEAD STAND

DWG NO.

RBT18657-7

REV
8

MAT'L A36/1018/1020 HR

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

HEAT

.XXX ± .010 FRACTIONS ± 1/8

TREAT

.XX ± .03 ANGLES ± 1°

FINISH SEE -1 & -3

.X ± .1 SURFACES = 125 ✓

SPEC

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R

DRAWN BY: PERRITT

2. DIMENSIONAL LIMITS APPLY
AFTER PLATING

CHECKED: CLOUGH

3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

OPPS APPR: ANDERSON

USED ON MODEL

QA APPR: LINDSAY

FIRE SCOUT

APPROVED: GILBERT

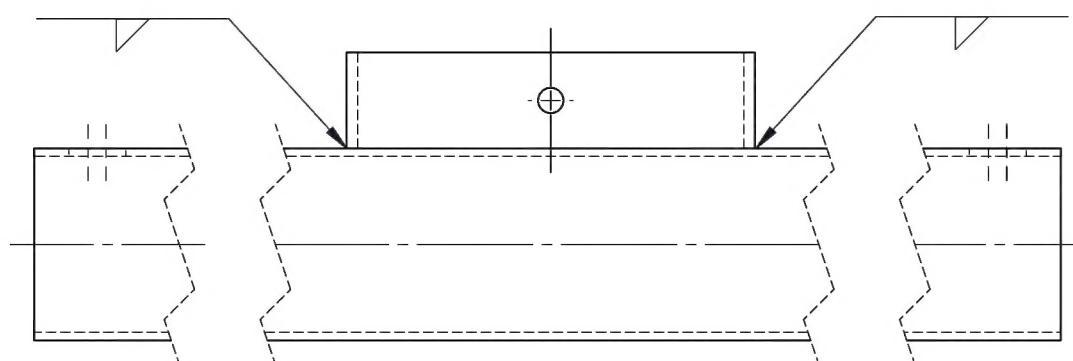
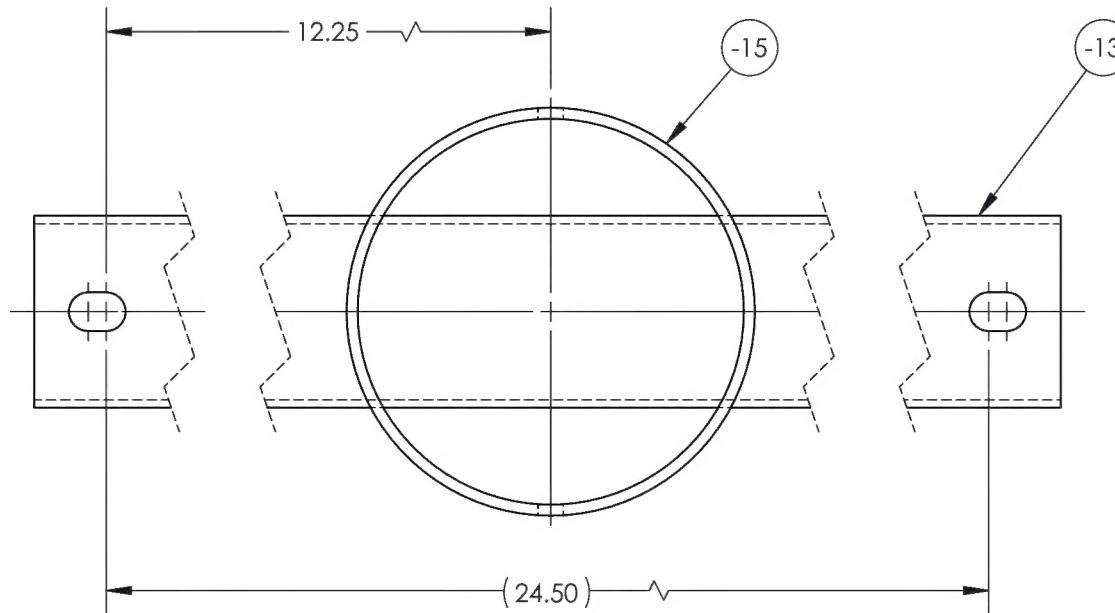
SCALE 1:1

DATE 10/3/2008

SHEET 7 OF 23

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REV			ECR			DESCRIPTION			DATE			INITIAL			APPROVED		
8	16-0189		-11 CH'D DIM WAS 24.50 IS (24.50).						10/25/2016			DPD			JAG		



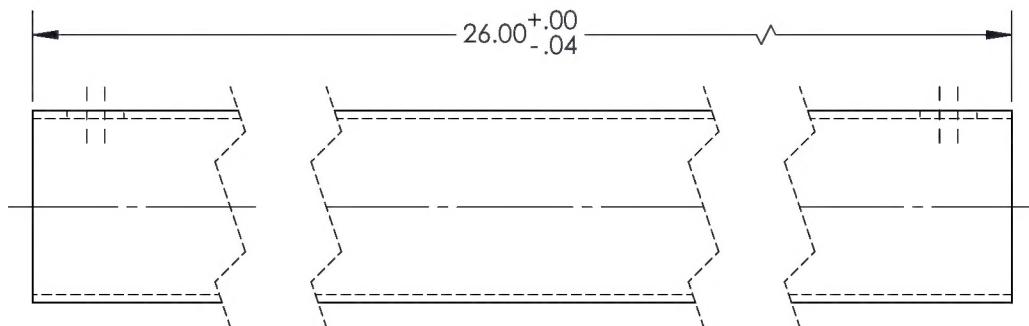
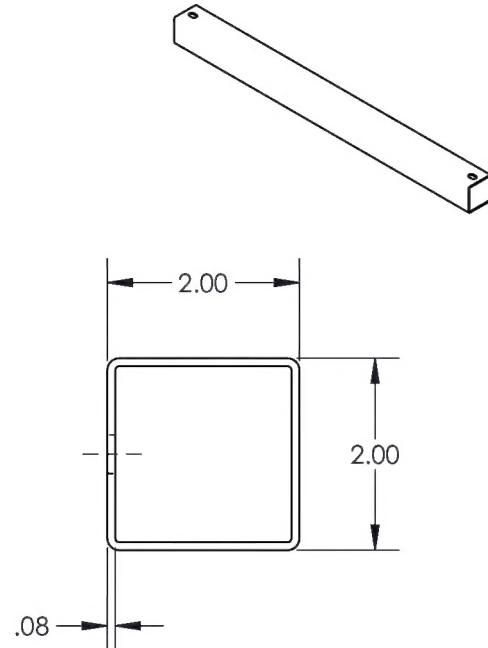
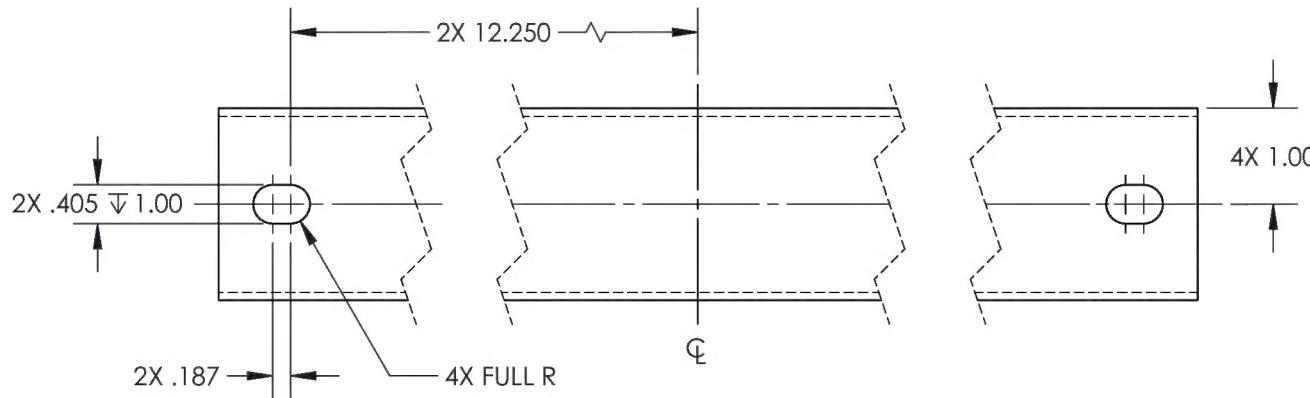
BASE CENTER TUBE WELDMENT

(-11)

DART AEROSPACE	
TITLE	
FIRE SCOUT ROTOR HEAD STAND	
DWG NO.	RBT18657-11
REV	8
MAT'L	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .010
TREAT	FRACTIONS ± 1/8
FINISH	POWDER COAT WHITE
SPEC	.XX ± .03
	ANGLES ± 1°
	X ± .1
	SURFACES = 125
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	PERRITT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
USED ON MODEL	
APPROVED:	GILBERT
FIRE SCOUT	
SCALE	1:2
DATE	10/3/2008
SHEET 8 OF 23	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5		CH'D Ø.405 HOLE TO A SLOT ON BOTH ENDS -13 PER G.E.	3/3/2011	RJC	GE
8	16-0189	-13 CH'D DIM WAS 1.00 (x2) IS 4X 1.00, WAS (2.00) IS 2.00, WAS (2.00) IS 2.00, WAS (.083) WALL IS .08.	10/25/2016	DPD	JAG



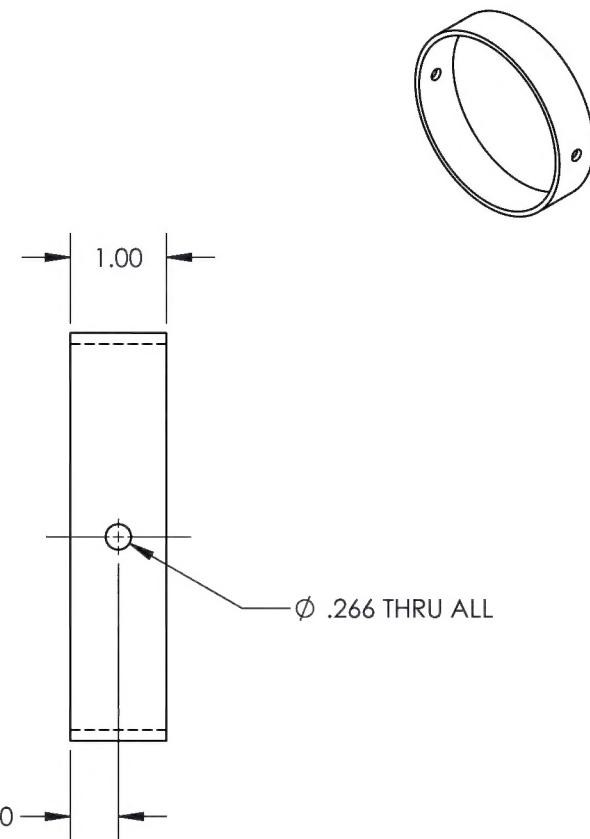
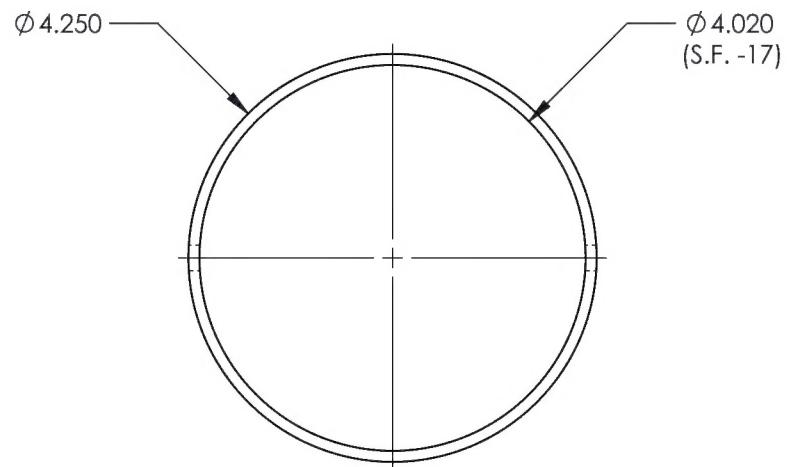
(-13)

BASE CENTER TUBE

DART AEROSPACE	
TITLE	
FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-13	
REV 8	
MATERIAL STEEL TUBE	
HEAT	
TREAT	
FINISH SEE -11	
SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
.X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	PERRITT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
FIRE SCOUT	
SCALE	1:2
DATE	10/3/2008
SHEET 9 OF 23	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8		-15 CH'D DIM WAS Ø4.00 S.F. -17 AFTER POWDER COATING IS Ø4.020 (S.F. -17).	10/25/2016	DPD	JAG



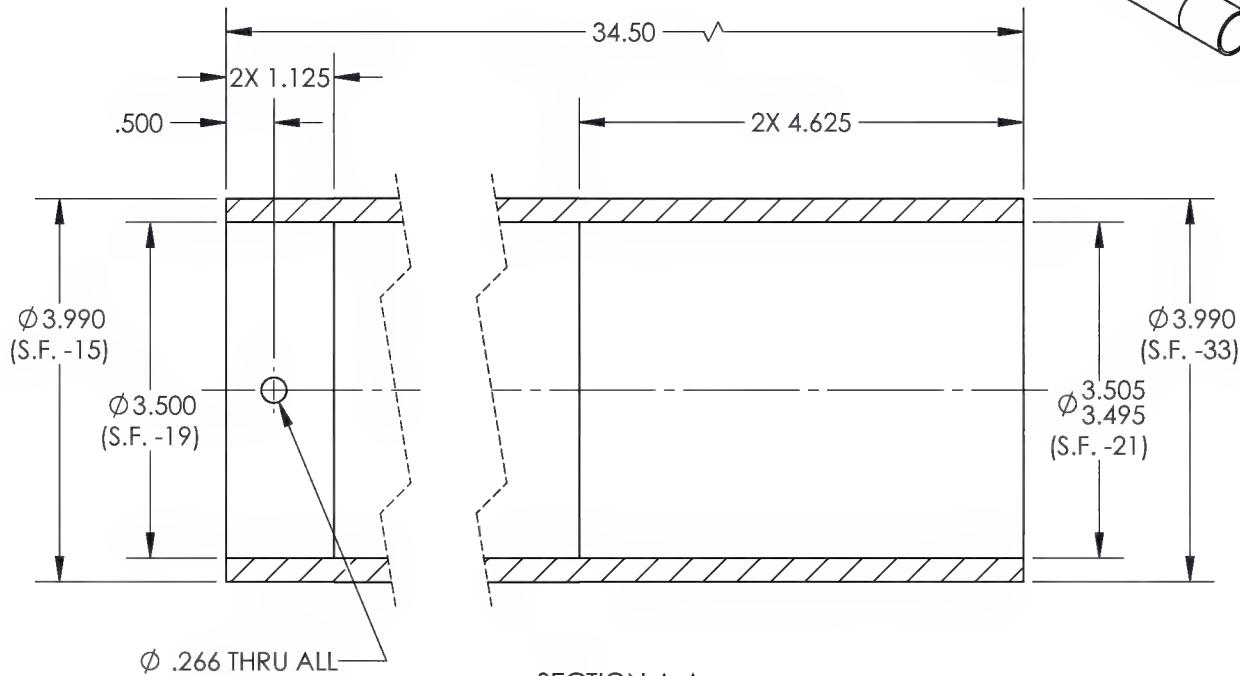
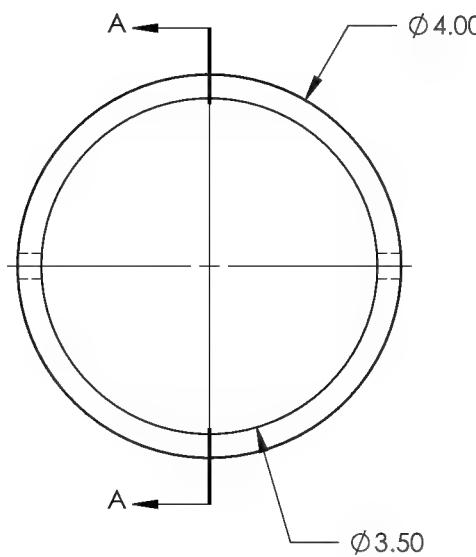
-15

BASE CENTER TUBE RING

	
TITLE	FIRE SCOUT ROTOR HEAD STAND
DWG NO.	RBT18657-15
REV	8
MAT'L DOM	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH SEE -11	X ± .1 SURFACES = 125 ✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY:	PERRITT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	FIRE SCOUT
SCALE	1:2
DATE	10/3/2008
SHEET	10 OF 23

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			REVISIONS		
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADJUSTED -17 TO ALLOW FOR OVERSIZE PLASTIC TUBE CONDITIONS.	11/24/2008	WP	RW
8	16-0189	-17 CH'D DIM WAS Ø3.500 S.F. -21 IS Ø3.495-3.505 (S.F. -21). ADDED DIMS Ø3.50, Ø4.00. CH'D MAT'L FROM NATURAL TO NATURAL, NYLON.	10/25/2016	DPD	JAG



SECTION A-A



TITLE
FIRE SCOUT ROTOR HEAD STAND

DWG NO.

RBT18657-17

REV
8

MAT'L NATURAL, NYLON

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES

HEAT .XXX ± .010 FRACTIONS ± 1/8

TREAT .XX ± .03 ANGLES ± 1°

FINISH X ± .1 SURFACES = 125

SPEC .015 x 45° OR .015R

DRAWN BY: PERRITT

1. BREAK ALL SHARP EDGES

CHECKED: CLOUGH

.015 x 45° OR .015R

OPPS APPR: ANDERSON

2. DIMENSIONAL LIMITS APPLY

QA APPR: LINDSAY

AFTER PLATING

APPROVED: GILBERT

3. INTERPRET DIM AND TOL PER

ASME Y14.5M-2009

USED ON MODEL

FIRE SCOUT

SCALE 1:2

DATE 10/3/2008

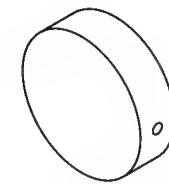
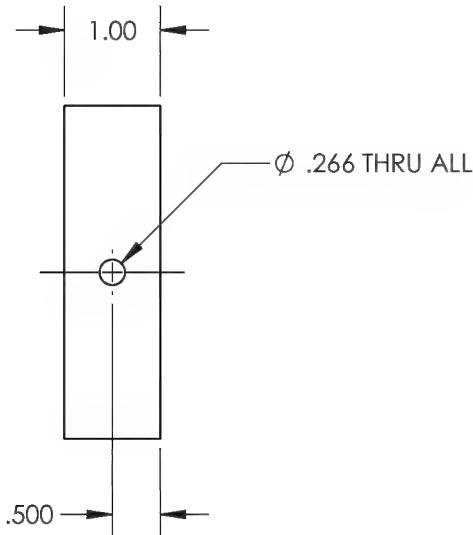
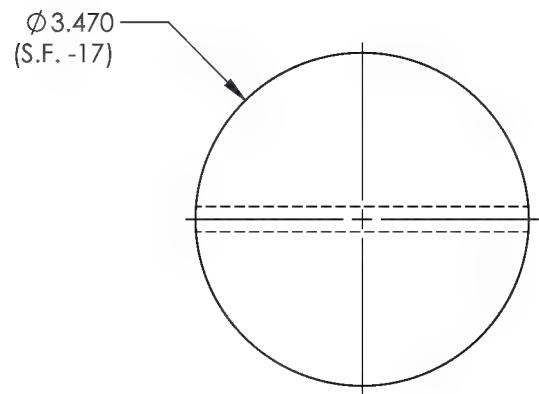
SHEET 11 OF 23

(-17)

VERTICAL NYLON TUBE

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8	16-0189	-19 CH'D DIM WAS $\varnothing 3.500$ S.F. -17 IS $\varnothing 3.470$ (S.F. -17). CH'D MATTL WAS DELRIN IS WHITE DELRIN/ACETAL.	10/25/2016	DPD	JAG



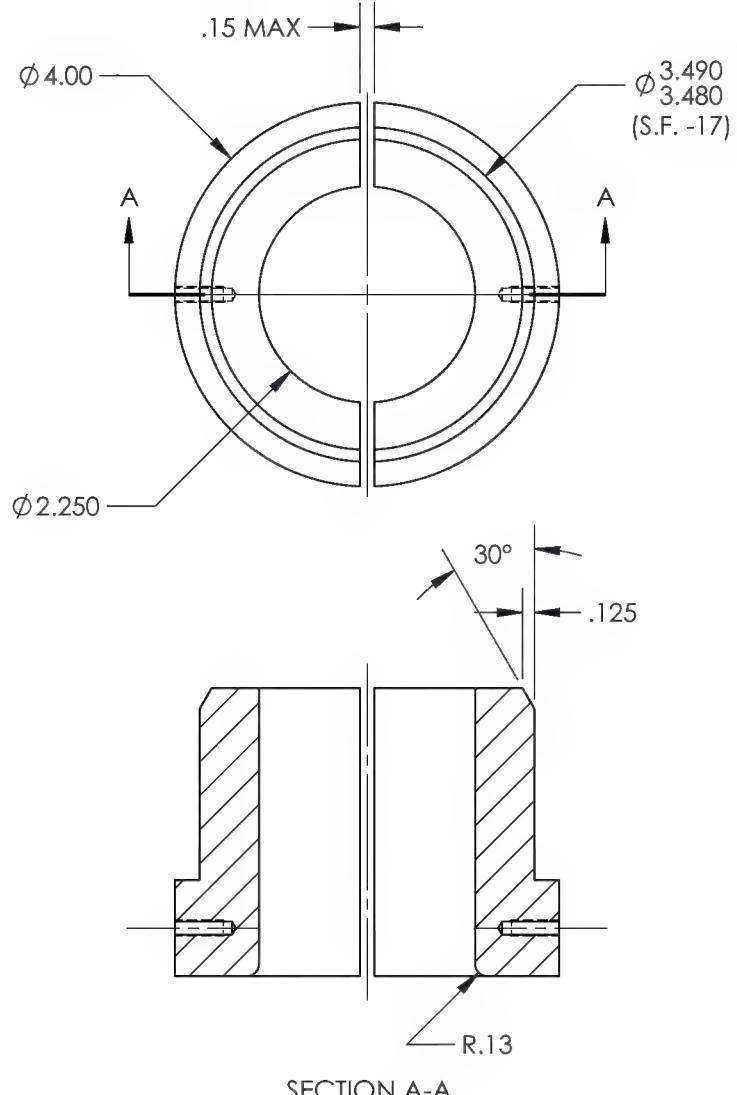
-19

TUBE BOTTOM PLUG

TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO.	RBT18657-19
REV	8
MAT'L	WHITE DELRIN/ACETAL
HEAT	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
DRAWN BY:	PERRITT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	FIRE SCOUT
SCALE	1:2
DATE	10/3/2008
SHEET	12 OF 23

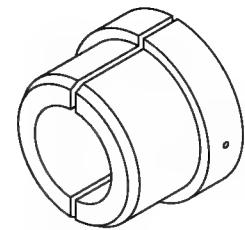
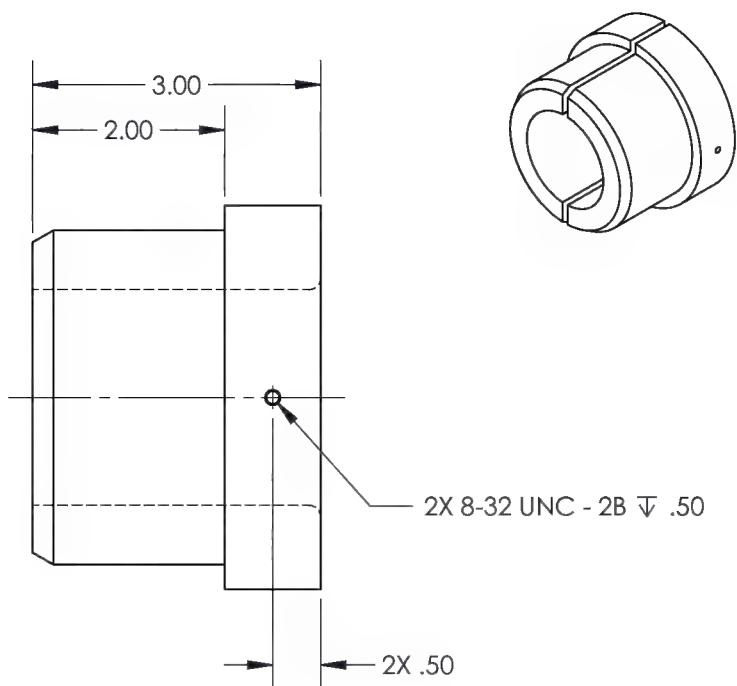
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REV			ECR			DESCRIPTION			REVISIONS			
REV	ECR	DATE	INITIAL	APPROVED	REV	ECR	DATE	INITIAL	APPROVED	REV	ECR	
8	16-0189	-21 CH'D DIM WAS $\varnothing 3.490$ IS $\varnothing 3.480-3.490$ (S.F. -17). CH'D MAT'L WAS DELRIN IS WHITE DELRIN/ACETAL.								10/25/2016	DPD	JAG



(21)

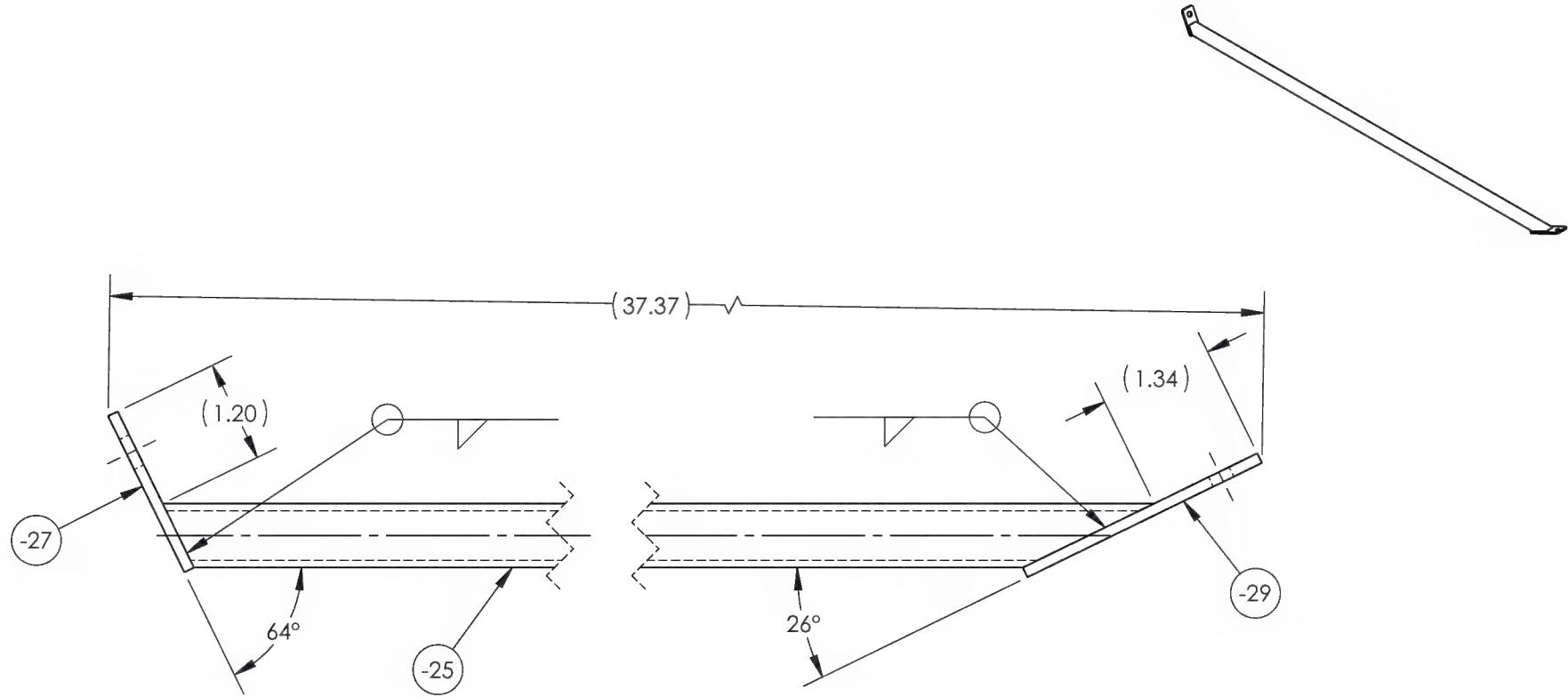
SUPPORT INSERT



	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO.	RBT18657-21
REV	8
MAT'L WHITE DELRIN/ACETAL UNLESS OTHERWISE SPECIFIED HEAT .XXX \pm .010 DIMENSIONS ARE IN INCHES TREAT .XX \pm .03 FRACTIONS \pm 1/8 FINISH .X \pm .1 ANGLES \pm 1° SURFACES = 125	
SPEC DRAWN BY: PERRITT 1. BREAK ALL SHARP EDGES CHECKED: CLOUGH .015 x 45° OR .015R OPPS APPR: ANDERSON 2. DIMENSIONAL LIMITS APPLY QA APPR: LINDSAY AFTER PLATING APPROVED: GILBERT 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL FIRE SCOUT	
SCALE	1:2
DATE	10/3/2008
SHEET	13 OF 23

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		-23 DELETED NOTE 1 WAS ASSEMBLE WITH ALL TUBE SEAMS ON THE BOTTOM.	8/12/2013	RJC	DW
8	16-0189	-23 CH'D DIM WAS (37.34) IS (37.37). ADDED WELD SYMBOLS.	10/25/2016	DPD	JAG

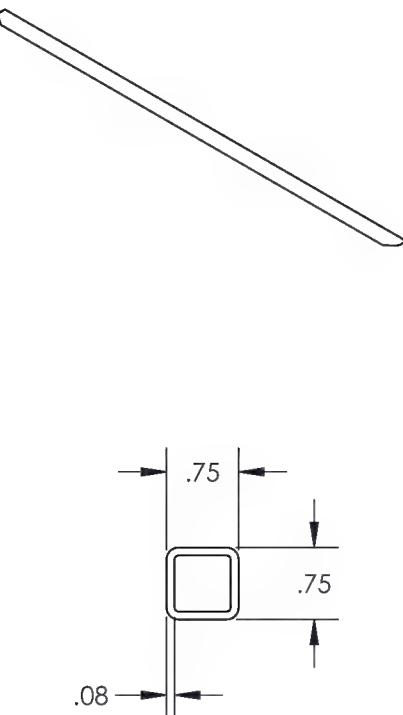
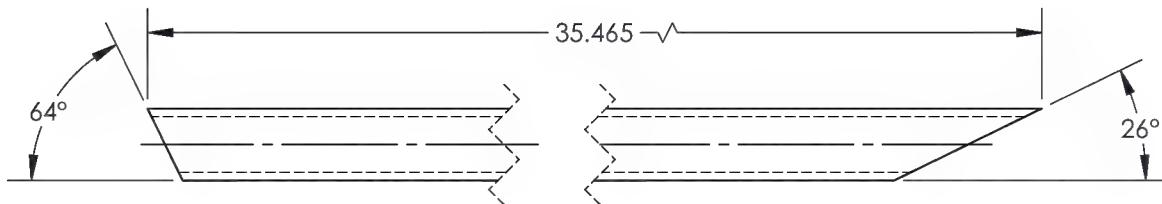


BRACE WELDMENT

DART AEROSPACE	
TITLE	
FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-23	
REV	8
MATERIAL	
HEAT	
TREAT	
FINISH POWDER COAT WHITE	
SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
.X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	PERRITT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
FIRE SCOUT	
SCALE	1:2
DATE	10/3/2008
SHEET 14 OF 23	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8	16-0189	-25 CH'D DIMS WAS (.75) IS .75, WAS (.75) IS .75, WAS (.083) WALL IS .08. CH'D MAT'L WAS 1018 SQ. TUBE IS STEEL TUBE.	10/25/2016	DPD	JAG



(-25)

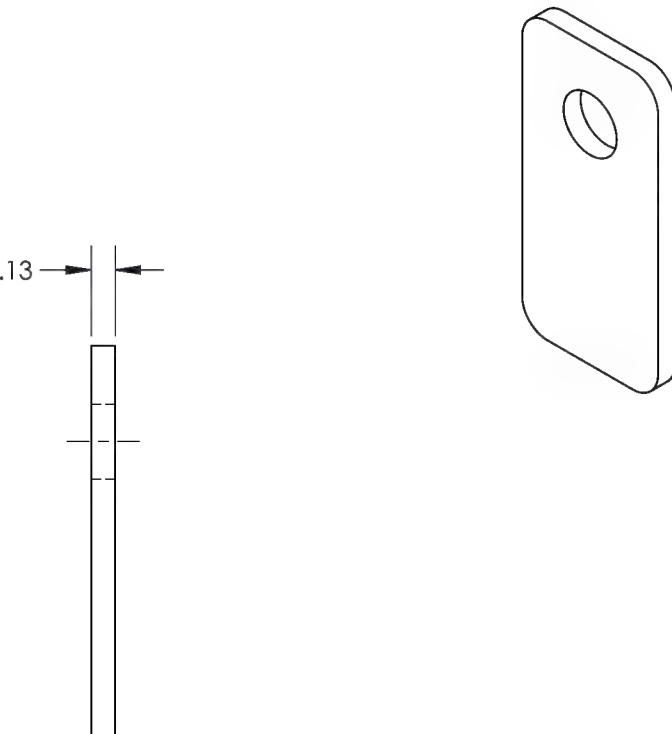
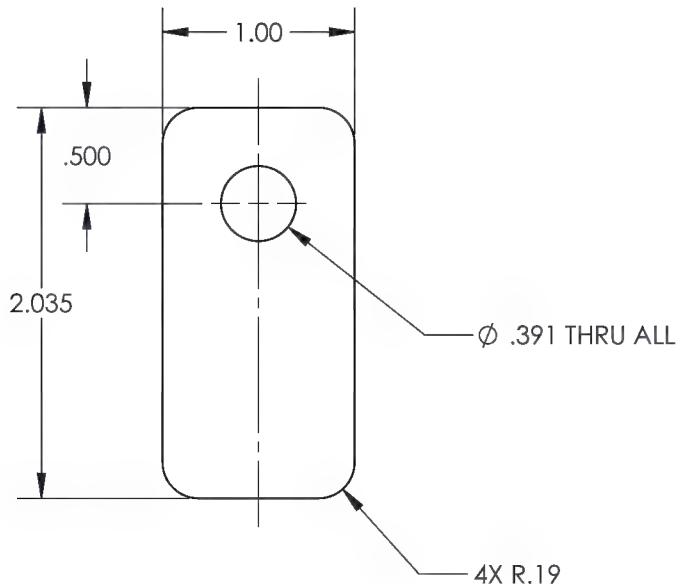
BRACE TUBE

	
TITLE	
MAT'L	STEEL TUBE
HEAT	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -23	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
DRAWN BY:	PERRITT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	1:2
DATE	10/3/2008
USED ON MODEL	
FIRE SCOUT	
SHEET 15 OF 23	

REV
8

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8	16-0189	-27 CH'D DIM WAS (.125) IS .13. CH'D MAT'L WAS A709 GRD 36 IS A36/1018/1020 HR.	10/25/2016	DPD	JAG



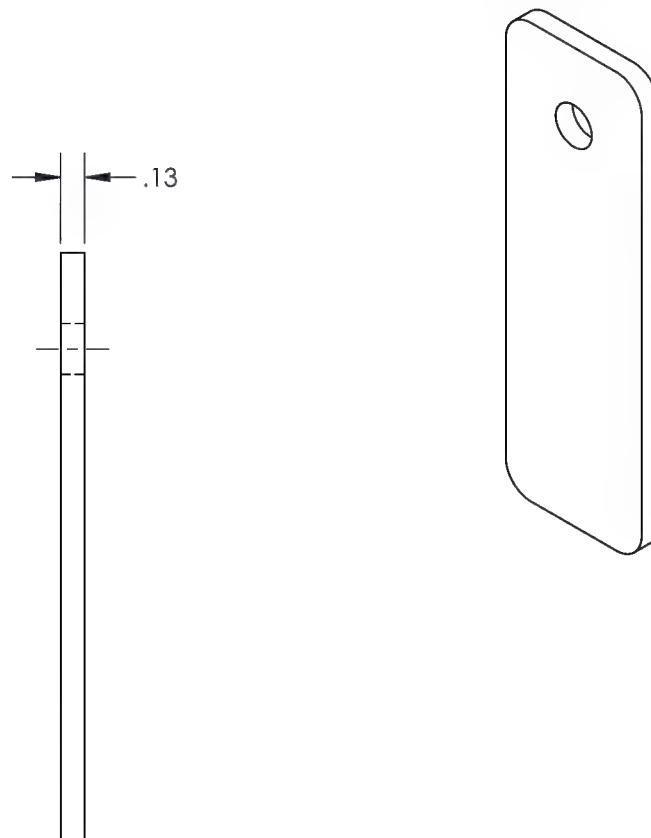
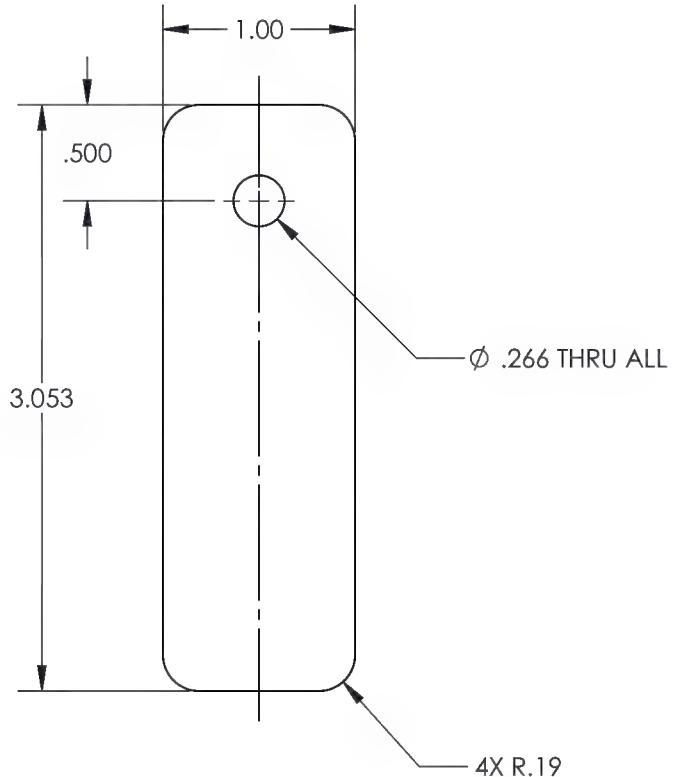
BOTTOM BRACE TAB

(-27)

DART AEROSPACE	
TITLE	
FIRE SCOUT ROTOR HEAD STAND	
DWG NO.	
RBT18657-27	
REV 8	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.000 ± .010 FRACTIONS ± 1/8	
.000 ± .03 ANGLES ± 1°	
.000 ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: PERRITT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL	
FIRE SCOUT	
SCALE	1:1
DATE	10/3/2008
SHEET 16 OF 23	

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REV			ECR			DESCRIPTION			DATE			INITIAL			APPROVED		
8	16-0189		-29 CH'D DIM WAS (.125) IS .13. CH'D MAT'L WAS A709 GRD 36 IS A36/1018/1020 HR.						10/25/2016			DPD			JAG		



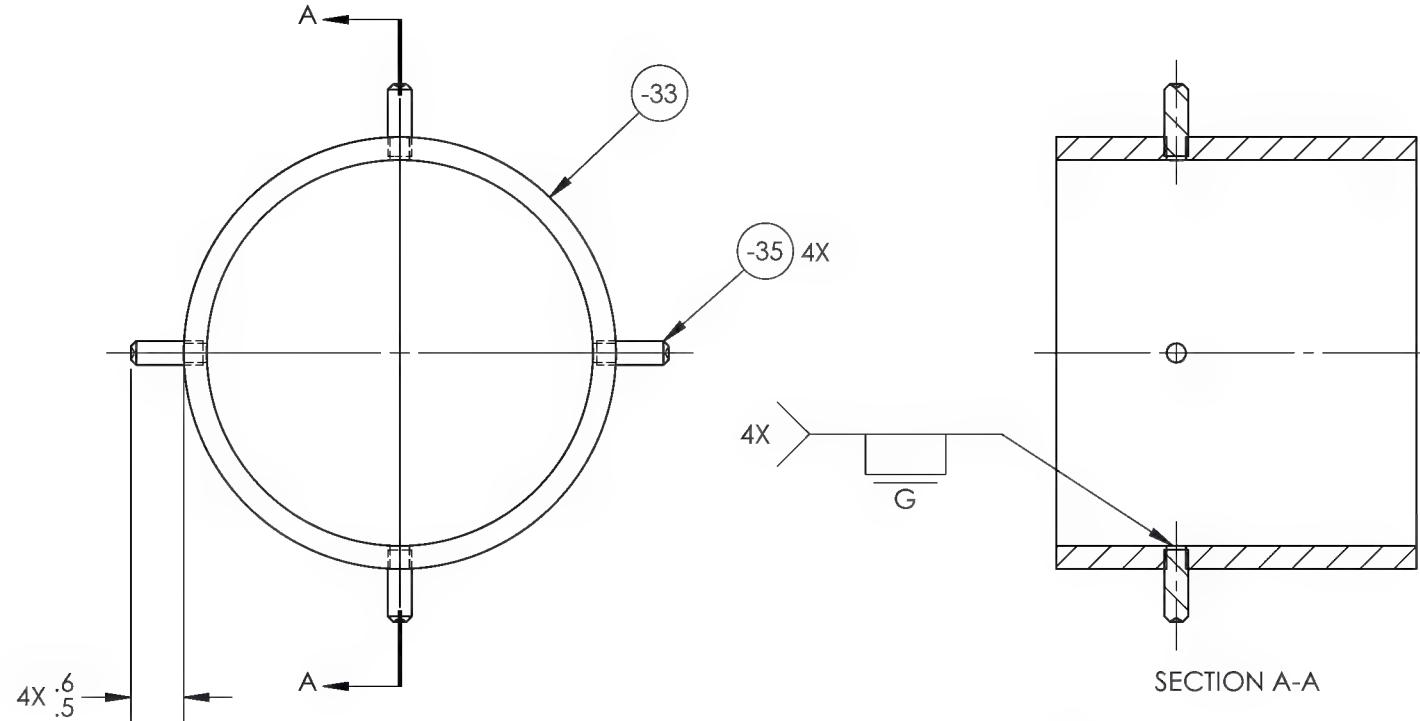
UPPER BRACE TAB

-29

	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO.	RBT18657-29
REV	8
MAT'L	A36/1018/1020 HR
HEAT	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .010 FRACTIONS ± 1/8
SEE -23	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125 ✓
DRAWN BY:	PERRITT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	FIRE SCOUT
SCALE	1:1
DATE	10/3/2008
SHEET	17 OF 23

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			REVISIONS			
REV	ECR		DESCRIPTION	DATE	INITIAL	APPROVED
7			-31 ADDED .5 MIN .6 MAX DIM.	8/12/2013	RJC	DW
8	16-0189		-31 ADDED NO POWDER COAT ON THREADS NOTE.	10/25/2016	DPD	JAG



NOTE:
NO POWDER COAT ON THREADS.



TITLE
FIRE SCOUT ROTOR HEAD STAND

DWG NO. **RBT18657-31** REV **8**

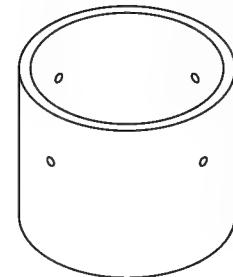
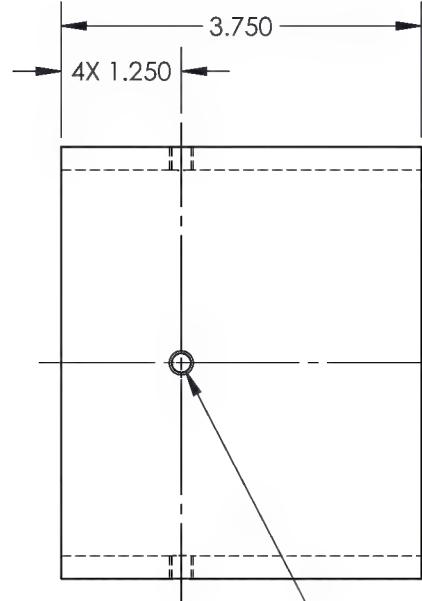
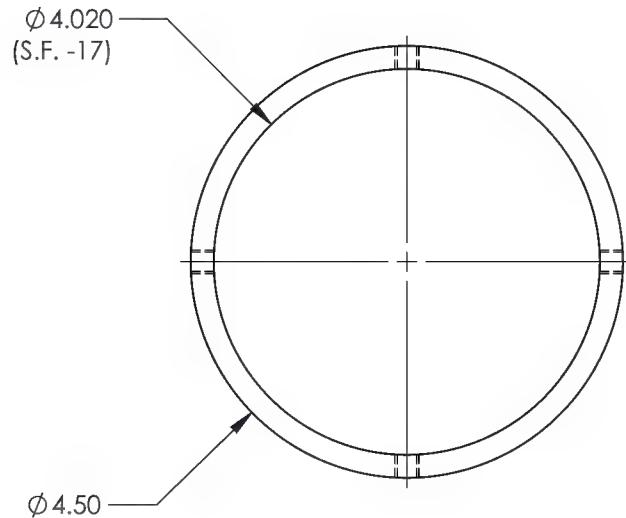
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH	.X ± .1 SURFACES = 125 ✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY:	PERRITT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	FIRE SCOUT
SCALE 1:2	DATE 10/3/2008
	SHEET 18 OF 23

-31

TUBE TOP RING WELDMENT

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		CH'D LENGTH -33 FROM 4.250 TO 3.750 PER D.W.	1/15/2010	RJC	RW
8	16-0189	-33 CH'D DIM WAS Ø4.000 S.F. -17 AFTER POWDER COATING IS Ø4.020 (S.F. -17).	10/25/2016	DPD	JAG



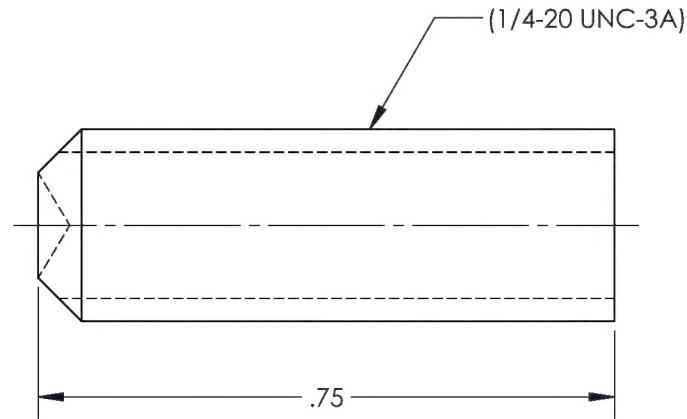
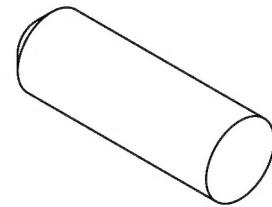
TUBE TOP RING

(33)

DART AEROSPACE	
TITLE	
FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-33	
REV 8	
MATERIAL DOM	
HEAT	
TREAT	
FINISH SEE -31	
SPEC	
DRAWN BY: PERRITT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE 1:2	DATE 10/3/2008
USED ON MODEL	
FIRE SCOUT	
SHEET 19 OF 23	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		-35 CH'D FROM STEEL TO STAINLESS & ADDED DWG TO MODIFY AND NOTE.	8/12/2013	RJC	DW



NOTE:
CUT TO LENGTH FROM SOCKET END.



TITLE
FIRE SCOUT ROTOR HEAD STAND

DWG NO. RBT18657-35 **REV** 8

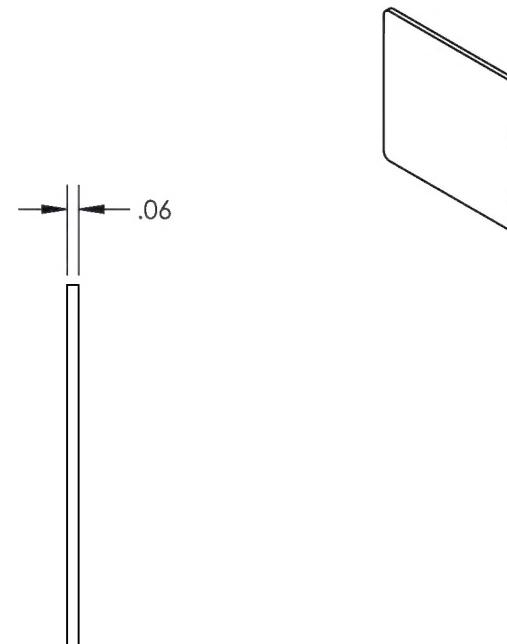
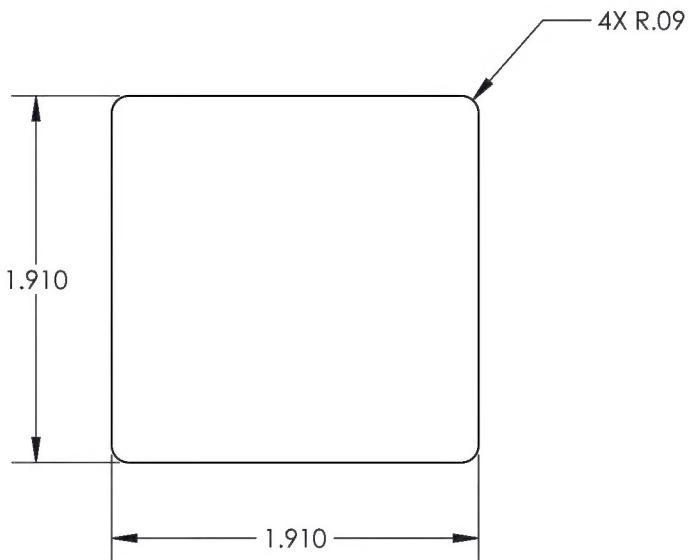
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH	X ± .1 SURFACES = 125
SPEC	✓
DRAWN BY:	PERRITT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	4:1
DATE	10/3/2008
USED ON MODEL	
FIRE SCOUT	
ASME Y14.5M-2009	
SHEET 20 OF 23	

(-35)

SOCKET HEAD SET SCREW

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8	16-0189	-43 CH'D DIM WAS 16ga. (.060) IS .06. CH'D MATL WAS A709 GRD 36 IS A36/1018/1020 HR.	10/25/2016	DPD	JAG



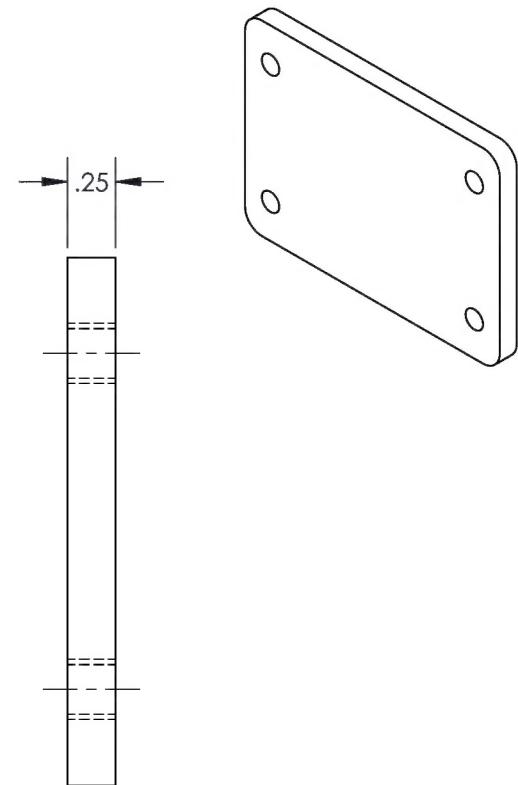
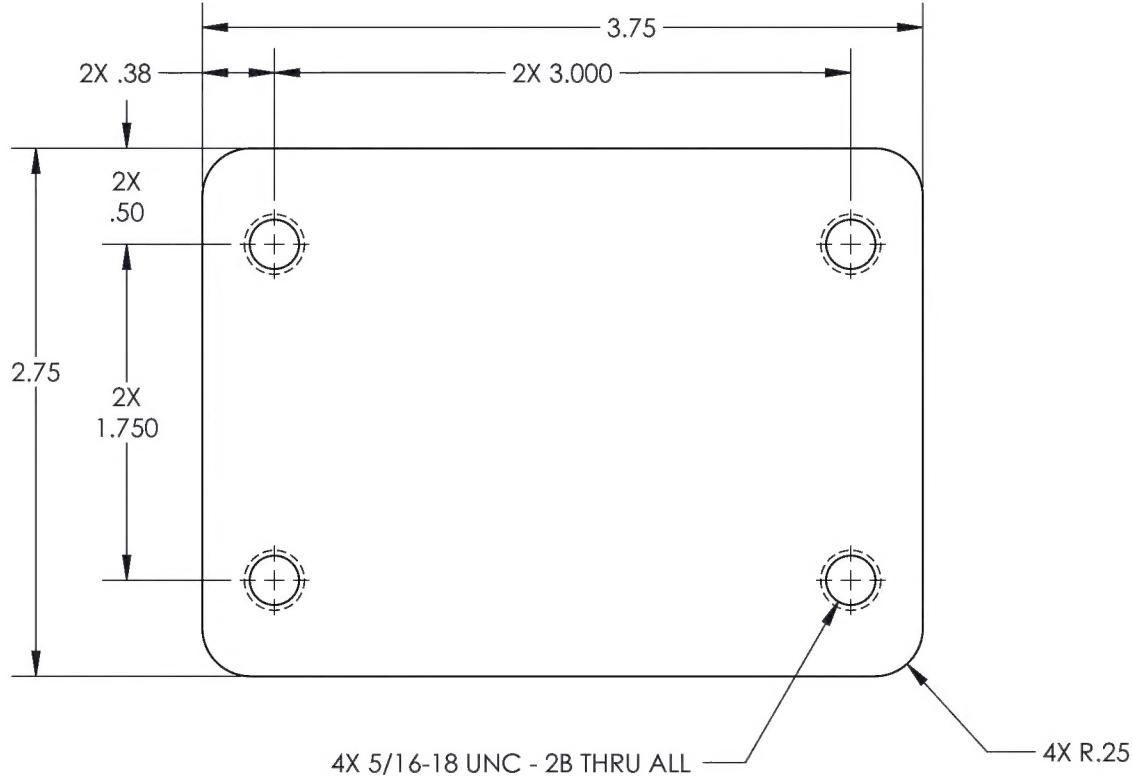
DART AEROSPACE	
TITLE	
FIRE SCOUT ROTOR HEAD STAND	
DWG NO.	
RBT18657-43	
REV 8	
MAT'L A36/1018/1020 HR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
.X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	PERRITT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
FIRE SCOUT	
SCALE	1:1
DATE	10/3/2008
SHEET 21 OF 23	

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BASE TUBE END CAP

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REV			ECR			DESCRIPTION			REVISIONS		
REV	ECR	DATE	INITIAL	APPROVED							
8	16-0189	-51	CH'D DIMS WAS (.25) IS .25, WAS .375 IS 2X .38, WAS 3.000 IS 2X 3.000, WAS .50 IS 2X .50, WAS 1.750 IS 2X 1.750. CH'D MAT'L WAS A709 GRD 36 IS A36/1018/1020 HR.	10/25/2016	DPD	JAG					



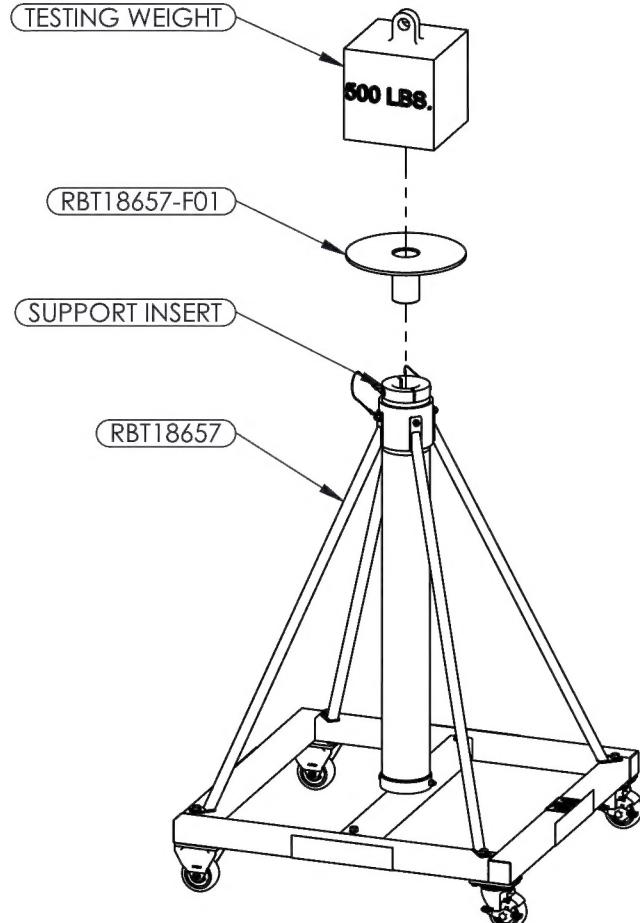
TITLE
FIRE SCOUT ROTOR HEAD STAND

DWG NO. RBT18657-51 **REV** 8

MATERIAL A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .010	FRACTIONS ± 1/8
TREAT	.XX ± .03	ANGLES ± 1°
FINISH SEE -1 & -3	X ± .1	SURFACES = 125
SPEC		✓
DRAWN BY:	PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED:	CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR:	ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR:	LINDSAY	USED ON MODEL
APPROVED:	GILBERT	FIRE SCOUT
SCALE	1:1	DATE 10/3/2008
		SHEET 22 OF 23

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WHEEL PLATE



INSPECTOR: _____

TESTER: _____

S.N.: _____

DATE: _____

INSPECTION & TESTING PROCEDURES FOR THE RBT18657 ROTOR HEAD STAND ASSEMBLY. THE RBT18657 IS DESIGNED FOR HOLDING THE FIRE SCOUT ROTOR HEAD DURING MAINTENANCE PROCEDURES. THIS ASSEMBLY SHOULD BE INSPECTED BEFORE AND AFTER EACH USE.
REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USING!

91 DAY INSPECTION:

1. CLEAN ENTIRE UNIT AND REMOVE CORROSION.
2. CHECK THE ENTIRE UNIT FOR DAMAGE, CRACKS, AND DISTORTIONS.
3. CHECK ALL BOLTS FOR TIGHTNESS AND DAMAGE. TIGHTEN OR REPLACE IF NECESSARY.
4. CHECK THE SUPPORT INSERT ASSEMBLY FOR CRACKS AND DAMAGE.
5. CHECK ALL WELDS FOR CRACKING AND DISTORTION.
6. CHECK ALL WHEELS FOR CRACKS AND SMOOTHNESS OF OPERATION.
7. LUBRICATE WHEELS WITH MIL-L-7870 GENERAL PURPOSE OIL. REPAINT IF NECESSARY.

IF ANY DAMAGE IS FOUND, REPAIR OR REPLACE THE UNIT.

3 YEAR WEIGHT TESTING:

1. PLACE THE RBT18657-F01 TESTING FIXTURE INTO THE SUPPORT INSERT.
2. PLACE A 500 LB. TESTING WEIGHT ON TOP OF THE TESTING FIXTURE FOR 5 MINUTES WHILE EXAMINING THE ROTOR HEAD STAND FOR CRACKS OR DISTORTIONS.
3. AFTER 5 MINUTES REMOVE THE TESTING WEIGHT AND FIXTURE.
4. RE-INSPECT ENTIRE ASSEMBLY.

SWL: 250 LBS.

DART AEROSPACE		
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dartaerospace.com		
TITLE: FIRE SCOUT ROTOR HEAD STAND		
DWG NO.	RBT18657	REV 8
SCALE	1:16	DATE 10/3/2008
SHEET	23 OF 23	